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(54) **A method of manufacturing a structural body and a apparatus therefor**

(57) In a friction stir joining apparatus la members 20, 30 subjected to friction stir joining are fixed on a table 5. A joining head 200 which moves in direction A has a rotary tool 10 which performs the friction stir joining to form a joining bead 50. A sensor 210 irradiates a light

beam 212 and detects edge portions of the members, to control the joining head 200 position. A cutting means 12 on the rotary tool 10 cuts off a burr, and forms chips. An air jet injected from an air nozzle 240 prevents entry of the chips 60 to the sensor 210.



Description

Background of the Invention:

[Technical Field]

[0001] The present invention relates to a manufacturing method of a structure body and a manufacturing apparatus of a structure body, and a friction stir joining method for a structure body and a friction stir joining apparatus for a structure body.

[Prior Art]

[0002] Two members to be subjected to a friction stir joining having a raised portion at an end portion thereof are abutted and from a side of the raised portion a rotary tool is inserted and then a friction stir joining is carried out. In this friction stir joining when a gap exists between two members to be subjected to the friction stir joining a reduced thickness of two members to be the subjected to the friction stir joining is compensated.

[0003] After the friction stir joining, when the raised portion of two members to be the subjected to the friction stir joining is unnecessary the raised portion is cut off or deleted and is removed the raised portion which is cut off or deleted and an outer face of the member to be subjected to the friction stir joining is formed flatly. This technique is disclosed in Japanese application patent laid-open publication No. Hei 09-309164 (EP 0797043 A2).

[0004] Further, a cutter is provided to a radial direction of the rotary tool. The small diameter portion of the rotary tool is inserted into a joining portion and a boundary formed between the large diameter portion and the small diameter portion of the rotary tool is contacted to the members to be subjected to the friction stir joining.

[0005] The cutter is projected toward a side of the large diameter portion of the rotary tool from the above stated boundary. This cutter can cut off or delete burr which is generated according to the friction stir joining. This technique is disclosed in Japanese application patent laid-open publication No. Hei 10-71477 (US Patent No. 5794835, EP 0810055 A1).

[0006] Further, the rotary tool and the cutter are provided separately, and as the cutter an end milling is used. This technique is disclosed in Japanese application patent laid-open publication No. Hei 10-175089.

[0007] When the members to be subjected to the joining having the raised portion at the end portion thereof are carried out to the friction stir joining to the joining portion the burr is generated. Further, the raised portion of the member to be subjected to the friction stir joining is left. In a case where the raised portion side is formed to an outer face of a structure body, it is necessary to remove the raised portion according to the cut-out.

[0008] Herein, to the rotary tool the cutter is attached, by the joining it is necessary to cut off an excessive

raised portion and the burr.

[0009] According to the cut-out, chips generate. According to the existence of the chips it is difficult to carry out a good friction stir joining.

[0010] The above stated reasons will be explained. To a front portion of an advancing direction of the rotary tool an optical sensor for detecting optically the raised portion of the member to be subjected to the friction stir joining is provided. This optical sensor can detect a width of the two raised portions of the member to be subjected to the friction stir joining and the rotary tool is positioned at a center thereof. Further, the optical sensor can detect a height of the raised portion of the member to be subjected to the friction stir joining and an insertion amount of the rotary tool to the members to be subjected to the friction stir joining can be determined suitably.

[0011] To a detection range of the optical sensor when the chips enter and then it is impossible to carry out a precise detection.

[0012] Further, at a front portion and at a rear portion of the rotary tool rollers are installed, such rollers presses the raised portion of the member to be subjected to the friction stir joining or the member to be subjected to the friction stir joining at a vicinity of the raised portion to a bed. Since at the rear portion of the rotary tool the chips are mounted mainly, the rear portion roller presses the chips. For this reason, the member to be subjected to the friction stir joining is injured according to the chips.

Summary of the Invention:

[0013] An object of the present invention is to a manufacturing method of a structure body and a manufacturing apparatus of a structure body, and a friction stir joining method for a structure body and a friction stir joining apparatus for a structure body wherein a good structure body can be obtained.

[0014] Another object of the present invention is to a manufacturing method of a structure body and a manufacturing apparatus of a structure body, and a friction stir joining method for a structure body and a friction stir joining apparatus for a structure body wherein a structure body having a small raised portion can be obtained.

[0015] The above stated objects can be attained between a cutting means and a sensing means by flowing out air from a front portion side of a moving direction directing for a rear portion or from a lateral direction against to the moving direction.

[0016] The above stated objects can be attained by using a cutter which has a rotation radius larger than a width of a raised portion of a structure body.

[0017] The above stated objects can be attained in a manufacturing method of a structure body in which moving relatively a cutting means with a joining portion and leading said cutting means according to a sensing means for detecting said joining portion in a rear portion of a moving direction and cutting said joining portion,

between said cutting means and said sensing means, flowing out air from a front portion of said moving direction to a rear portion or from a lateral direction toward said moving direction.

[0018] The above stated objects can be attained by in a manufacturing method of a structure body in which leading a cutting means according to a sensing means for detecting a joining portion in a rear of an advancing direction and cutting off said joining portion, flowing out air directing for a rear portion of said sensing means from a side of a front portion of said advancing direction from said sensing means toward the rear portion of said sensing means.

[0019] The above stated objects can be attained by a friction stir joining apparatus for a structure body comprises a bed for fixing members to be subjected to a joining, a head for carrying out a friction stir joining said members by moving relatively against said bed, said head comprises a rotary tool having a burr removing friction stir joining use cutting means and a sensing means provided to a front portion of an advancing direction against said rotary tool and for detecting a center position of said joining portion, a cover for covering a housing of said sensing means, and an air nozzle for injecting an air jet against said cover.

Brief Description of Drawing:

[0020]

Fig. 1 is a side face view of a friction stir joining apparatus for a structure body according to the present invention;

Fig. 2 is a side face view showing an essential part of the friction stir joining apparatus for the structure body of Fig. 1;

Fig. 3 is a plan view of the friction stir joining apparatus for the structure body of Fig. 2;

Fig. 4 is an explanatory view showing a relationship between a rotary tool and members to be subjected to a friction stir joining;

Fig. 5 is an explanatory view showing a relationship between a rotary tool and members to be subjected to a friction stir joining;

Fig. 6(A) is an explanatory view showing one construction of the rotary tool;

Fig. 6(B) is an explanatory view showing another construction of the rotary tool;

Fig. 7(A) is an explanatory view showing a relationship between a rotary tool and a friction stir joining portion of the members to be subjected to the friction stir joining;

Fig. 7(B) is an explanatory view showing a friction stir joining portion of the members to be subjected to the friction stir joining;

Fig. 7(C) is an explanatory view showing a friction stir joining portion of the members to be subjected to the friction stir joining;

Fig. 7(D) is an explanatory view showing a friction stir joining portion of the members to be subjected to the friction stir joining;

Fig. 8 is a side face view showing another embodiment of a manufacturing method of a structure body and a manufacturing apparatus of a structure body, and a friction stir joining method for a structure and a friction stir joining apparatus for a structure according to the present invention;

Fig. 9 is a side face view showing another embodiment of a manufacturing method of a structure body and a manufacturing apparatus of a structure body, and a friction stir joining method for a structure body and a friction stir joining apparatus for a structure body according to the present invention;

Fig. 10 is a side face view showing a further embodiment of a manufacturing method of a structure body and a manufacturing apparatus of a structure body, and a friction stir joining method for a structure body and a friction stir joining apparatus for a structure body according to the present invention; and

Fig. 11 is a side face view showing a further embodiment of a manufacturing method of a structure body and a manufacturing apparatus of a structure body, and a friction stir joining method for a structure body and a friction stir joining apparatus for a structure body according to the present invention.

Description of the Invention:

[0021] Fig. 1 is a side face view showing a manufacturing method of a structure body and a manufacturing apparatus of a structure body, and a friction stir joining method for a structure body and a friction stir joining apparatus for a structure body according to the present invention.

[0022] A friction stir joining apparatus for a structure body indicated with a reference numeral 1a in total comprises a table 5 on which two members 20 and 30 to be subjected to a friction stir joining are mounted, and a joining head 200 moves relatively at an arrow mark A direction against the table 5 with a first pressing roller unit 110 which is provided at a front portion of the joining head 200 and also a second pressing roller unit 120 which is provided at a rear portion of the joining head 200.

[0023] The first pressing roller unit 110 is arranged at a front portion of an advancing direction against the joining head 200 and a rotation roller 112 presses down upper faces of non-joining raised portions 22 and 32 of the members 20 and 30 to be subjected to the friction stir joining.

[0024] The first pressing roller unit 110 has an air nozzle 114 and this air nozzle 114 can remove foreign matters of the friction stir joining portion. Further, the first pressing roller 110 can remove foreign matters from a rolling face of the roller 112. An injection direction of an air jet of the air nozzle 114 is a front direction of a moving

direction A. Further, the injection direction of an air jet of the air nozzle 114 is a side portion against to the moving direction.

[0025] The second pressing roller unit 120 is arranged at a rear portion of the advancing direction of the joining head 200 and a rotation roller 112 presses down an upper face of a joining bead 50. The second pressing roller unit 120 has also an air nozzle 124 and this air nozzle 114 can remove chips etc. which are generated during a friction stir joining time. Further, the second pressing roller 120 can remove foreign matters from a rolling face of the roller 112. An injection direction of an air jet of the air nozzle 114 is a front direction of a moving direction A. Further, the injection direction of an air jet of the air nozzle 114 is a side portion against to the moving direction.

[0026] Fig. 2 is a side face view showing the joining head of the friction stir joining apparatus for the structure body and Fig. 3 is a plan view showing the joining head of the friction stir joining apparatus for the structure body.

[0027] The joining head 200 of the friction stir joining apparatus indicated with a reference numeral 1a in total moves relatively to the arrow mark A direction against the table 5 and also is move-controlled against a direction B orthogonal to the advancing direction and a height direction C.

[0028] On the table 5, the first member 20 to be subjected to the friction stir joining and the second member 30 to be subjected to the friction stir joining are installed by contacting or approaching joining end faces thereof. The first member 20 to be subjected to the friction stir joining has the joining use raised portion 22 and further the second member 30 to be subjected to the friction stir joining has the joining use raised portion 32.

[0029] The joining head 200 comprises the rotary tool 10 and the optical sensor 210. The rotary tool 10 moves toward the arrow mark A direction by rotating toward an arrow mark R direction and carries out the friction stir joining to the joining portion of the members 20 and 30 to be subjected to the friction stir joining and then the joining bead 50 is formed.

[0030] The rotary tool 10 has the burr removing cutter 12 and this cutter 12 cut off the burr etc. which generate during the friction stir joining time and removes them on the joining bead 50 as the chips 60.

[0031] The optical sensor 210 provided on the joining head 200 has a box shape housing and is covered by a cover 230. The cover 230 covers one of side faces of the optical sensor 210 and a front face which opposites to the rotary tool 10.

[0032] To a position which is an opposite side to the rotary tool 10 of the housing of the joining head 200, an air nozzle 240 is installed.

[0033] The optical sensor 210 projects a light beam 212 to the upper faces of the members 20 and 30 to be subjected to the friction stir joining and detects optically the positions of edge portions 24 and 34 of the raised

portions 22 and 32 of the members 20 and 30 to be subjected to the friction stir joining.

[0034] In accordance with the information of this optical sensor 210, the joining head 200 is moved and controlled toward the arrow mark B direction and a center of the rotary tool 10 is guided along to the center of the both edge portions 24 and 34 of the raised portions 22 and 32 of the members 20 and 30 to be subjected to the friction stir joining.

[0035] Further, the optical sensor 210 detects the height positions of apexes of the raised portions 22 and 32 of the members 20 and 30 to be subjected to the friction stir joining. According to this detection, the joining head or a processing head 200 is moved and controlled toward the arrow mark C direction and the insertion amount of the rotary tool 10 is determined at a predetermined value.

[0036] The rotary tool 10 has the burr removing cutter 12 and the cutter 12 cut off the burr which generate during the friction stir joining time and changes them to the chips 60. Further, the apex sides of the raised portions 22 and 32 are cut off and the cut-off matters are changed to the chips 60. According to a centrifugal force of the rotary tool 10, the chips 60 are dispersed toward a surrounding portion of the table 5.

[0037] A front face plate 232 of the cover 230 is folded with a fold angle of an obtuse angle α against a side face plate 231 which is in parallel with the advancing direction of the joining head 200 and covers a front side of the housing of the optical sensor 210. The front face plate 232 is inclined to against to the moving direction.

[0038] An air jet J is injected from the air nozzle to directing for the side face plate 231 which is provided at a vicinity of the front face plate 232. A height position of an injection port of the air nozzle is near to the raised portion 32.

[0039] The air jet J which has been run to the side face 231 of the cover 230 is deflected to an arrow mark F direction along to the side face plate 232 and then the chips 60 are scattered to an opened side portion of the cover 230. Accordingly, the chips 60 which have been entered in the cover 230 can be discharged. At a side portion of the moving direction since there is no side face plate, the chips 60 which have been entered in the cover 230 can be discharged easily.

[0040] The air jet J is injected from the air nozzle 240 which is provided at the rear portion of the housing of the optical sensor 210 and injects from a gap G which is formed at a lower face of the front face plate 232 of the cover 230 and removes the chips 60 which will enter to the cover 230. The air nozzle for injecting the air jet J may be provided a lateral direction of the optical sensor 210.

[0041] Further, the air jet J which has collided with a rear side of the front face plate of the cover 230 is deflected toward an arrow mark F direction along to the front face plate 232 and blows off the chips 60 toward a side portion in which the cover 230 is opened and

closed.

[0042] Fig. 4 shows a relationship between a rotation center axis C1 of the rotary tool 10 and the raised portions 22 and 32 of the members 20 and 30 to be subjected to the friction stir joining.

[0043] At a tip end portion of the rotary tool 10 the small diameter portion 14 is provided, and an outer periphery portion thereof the burr removing cutter 12 is formed.

[0044] Fig. 4 shows a condition in which the rotation center axis C1 of the rotary tool 10 is arranged in 90 degrees with the raised portions 22 and 32 of the members 20 and 30 to be subjected to the friction stir joining.

[0045] In a case of an actual friction stir joining time, as shown in Fig. 5, against the perpendicular line C1 with the surface of the member a rotation center axis C2 of the rotary tool 10 is joined by inclining with an angle of β . This angle β differs from the friction stir joining conditions and is selected with about 3 degree.

[0046] Each of Fig. 6(A) and Fig. 6(B) shows a position relationship between the tip end of the large diameter portion of the rotary tool 10 and the burr removing cutter 12. Fig. 6(A) shows a condition in which the lower end of the cutter 12 is provided with a stepwise difference from the tip end of the large diameter portion of the rotary tool 10 with a height dimension H1 against the tip end of the large diameter portion of the rotary tool 10. Fig. 6(B) shows a condition in which the lower end of the cutter 12 is arranged by projecting a height dimension H2 from the tip end of the large diameter portion of the rotary tool 10.

[0047] The arrangement position of the burr removing cutter 12 can be set, for example, the lower end of the burr removing cutter 12 may set to the height to the same against the tip end of the large diameter portion.

[0048] Each of Fig. 7(A), Fig. 7(B), Fig. 7(C) and Fig. 7(D) shows a condition of the joining bead portion.

[0049] As shown in Fig. 7(A), an outer diameter D1 of the large diameter portion of the rotary tool 10 is smaller than a width dimension L1 of the raised portions 22 and 32 of the members 20 and 30 to be subjected to the friction stir joining. And a rotation diameter D2 of the burr removing cutter 12 is set to be larger than the width dimension L1 of the raised portions 22 and 32 of the members 20 and 30 to be subjected to the friction stir joining.

[0050] As shown in Fig. 7(B), when the joining bead 50 is formed according to the friction stir joining apparatus, the burr 52 generates. With this condition as it is, a surface 50a of the joining bead 50 is positioned at a height position dimension T1 from the surface of the members 20 and 30 to be subjected to the friction stir joining.

[0051] Fig. 7(C) shows in which according to the cutter 12 the surface including the burr is cut off and a flat face 50b is formed at position of a height dimension T2.

[0052] Further, as shown in Fig. 7(D), the above stated surface is removed using a manual tool etc. and a flat face 50c same to the members 20 and 30 to be sub-

jected to the friction stir joining can be obtained.

[0053] Fig. 8 shows another embodiment of a friction stir joining apparatus for a structure body according to the present invention. A joining head 300 of a friction stir joining apparatus 1b of this embodiment according to the present invention has the rotary tool 10 but this rotary tool 10 has no burr removing cutter.

[0054] At a rear portion of the advancing direction of the rotary tool 10, a cutting tool 310 such as an end milling and this cutting tool 310 removes the burr which have generated to the joining bead.

[0055] Other constructions of the friction stir joining apparatus for a structure body of this embodiment according to the present invention are similarly to those of the former embodiment of the friction stir joining apparatus for a structure body according to the present invention shown in Fig. 1.

[0056] Fig. 9 shows a further embodiment of a friction stir joining apparatus for a structure body according to the present invention. A joining head 400 of a friction stir joining apparatus indicated by a reference numeral 1c of this embodiment has a welding torch 410 and a welding bead W1 is formed. According to a cutting tool 420 which is arranged at a rear portion of the welding torch 410 a surface of the welding bead W1 is cut off to form a flat face.

[0057] Other constructions of the friction stir joining apparatus for the structure body of this embodiment according to the present invention are similarly to those of the former embodiment of the friction stir joining apparatus for the structure body according to the present invention shown in Fig. 1.

[0058] Fig. 10 shows a further embodiment of a friction stir joining apparatus for a structure body according to the present invention. A head 400 of a friction stir joining apparatus indicated by a reference numeral 1d for the structure body of this embodiment according to the present invention has a cut-off tool 510 and to the raised portions 22 and 32 of the members 20 and 30 to be subjected to the friction stir joining and an upper face of the joining bead a necessary processing is performed.

[0059] Other constructions of the friction stir joining apparatus for the structure body of this embodiment according to the present invention are similarly to those of the former embodiment of the friction stir joining apparatus for the structure body according to the present invention shown in Fig. 1.

[0060] A technical range of the present invention is not limited to the wordings stated on each claim of claims or the wordings stated on the item of the means for solving the problem and further it refers to the range in which the man belonged to this technical field can replace easily.

[0061] As stated in above, according to the present invention, the friction stir joining apparatus for the structure body has a function in which the center of the joining portion is detected according to the optical sensor and to be consistent the center of the rotary tool with the

center of the joining portion the position control of a whole joining head is carried out.

[0062] Further, the optical sensor is arranged at the front portion of the rotary tool and the light beam is irradiated to the friction stir joining portion and detects optically the position of the joining portion. In this friction stir joining apparatus for the structure body, the optical sensor is covered according to the cover and the enter of the generated chips can be prevented.

[0063] The cover has the plate shape and the cover is constituted by the side face plate which covers one side portion which is in parallel to the advancing direction of the joining head of the box shape optical sensor housing and the front face plate which is folded to the obtuse angle against the side face plate and covers the face of the rotary tool side of the optical sensor housing.

[0064] Further, at the rear face portion of the optical sensor housing the air nozzle is provided and the air jet is injected toward the outside from the inner side of the cover. This air jet is injected to the outer side from the lower portion of the front face plate of the cover and the enter of the generated chips to the optical sensor side can be prevented.

[0065] Further, the air jet which has collided with the inner face of the cover is deflected by the front face plate of the cover and further is blown off to the side portion in which the optical sensor housing is opened.

[0066] Accordingly, the enter of the generated chips to the beam portion of the optical sensor and an accuracy degree can be improved.

[0067] Further, the pressing roller unit which is provided at the front and the rear portions of the joining head has the air nozzle and the chips on the members to be subjected to the friction stir joining can be removed and it does not occur the injure of the surface of the member to be subjected to the friction stir joining according to the steps on the generated chips by the pressing roller.

Claims

1. A method of manufacturing a structure body in which a cutting means is moved relatively to a joining portion and with said cutting means is a sensing means for detecting said joining portion characterised by
between said cutting means and said sensing means, passing out air rearwardly with respect to the moving direction or laterally with respect to the moving direction.
2. A method according to claim 1, wherein the air is passed out obliquely relative to said moving direction along a partitioning member which is provided between said sensing means and said cutting means.
3. A method according to claim 1 or 2, wherein the air

is passed out rearwardly relative to said moving direction from said sensing means.

4. A method according to claim 1, wherein said cutting means is installed offset from the rotation axis of friction stir joining rotary tool, the cutting accompanies friction stir joining.
5. A method according to claim 1, at least one first roller for pressing said members subjected to joining is provided rearwardly in said moving direction of said cutting means, and between said roller and said cutting means, air is passed out rearwardly or laterally.
6. A method according to claim 1 or 5, wherein at least one second roller for pressing said members subjected to joining is provided ahead of said cutting means and ahead of the second roller, air is passed out forwardly or laterally.
7. A method according to any one of claims 1 to 6 wherein the air is passed out from ahead of or at the front of said sensing means to a space between said sensing means and said joining portion.
8. A method according to any one of claims 1 to 6, wherein the air is passed out laterally to a space between said sensing means and said joining portion.
9. A method of manufacturing a structure body in which a cutting means is moved relatively to a joining portion and with said cutting means is a sensing means for detecting said joining portion characterised in that rolling means for pressing the joining material moves with the cutting means and between said rolling means and said cutting means, air is passed out forwardly or laterally.
10. A friction stir joining apparatus for manufacturing a structure body comprising:
 - a bed for fixing members to be subjected to joining;
 - a head for carrying out friction stir joining of said members by moving relatively to said bed, comprising a rotary tool having a burr removing cutting means and sensing means for detecting the position of the joint;
 - a cover for covering a housing of said sensing means, said cover comprising a first portion which is between said sensing means and said rotary tool and a second portion connecting to said first portion and at the side of said sensing means and has a side face along the movement direction; and
 - an air nozzle which is positioned in said cover

for injecting an air jet directed towards said side face and below said sensing means.

11. Apparatus according to claim 10, wherein said first portion of the cover which is positioned between said rotary tool and said sensing means is inclined toward said moving direction. 5

12. A friction stir joining method for manufacturing a structure body comprising: 10

abutting raised portions of two members, each having said raised portion at an edge thereof; carrying out a friction stir joining using a rotary tool which is inserted to said members from the side of said raised portions, and during the joining inclining said rotary tool so that a small diameter portion at a tip end of said rotary tool leads a large diameter portion of said rotary tool in the movement direction of the tool along the joint, and positioning the end face of said large diameter portion of said rotary tool within said raised portions between the upper faces thereof and the level of adjacent outer faces of said members; and 15 20 25

by means of cutting means provided on said large diameter portion near said small diameter portion projecting outwardly with a rotation radius larger than half the lateral width of said two raised portions, cutting said raised portions during the friction stir joining between said upper faces and said outer faces. 30

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FIG. 1

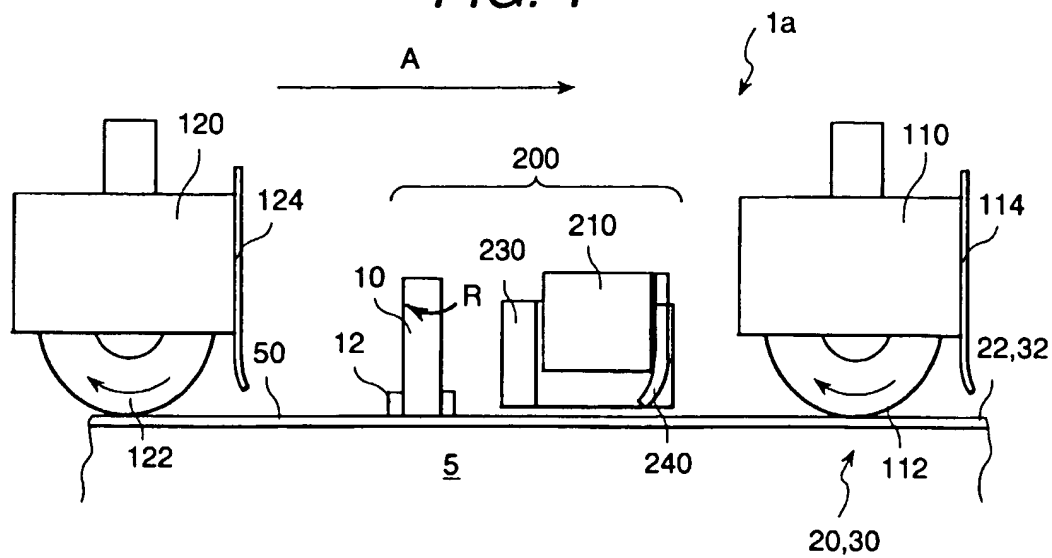


FIG. 2

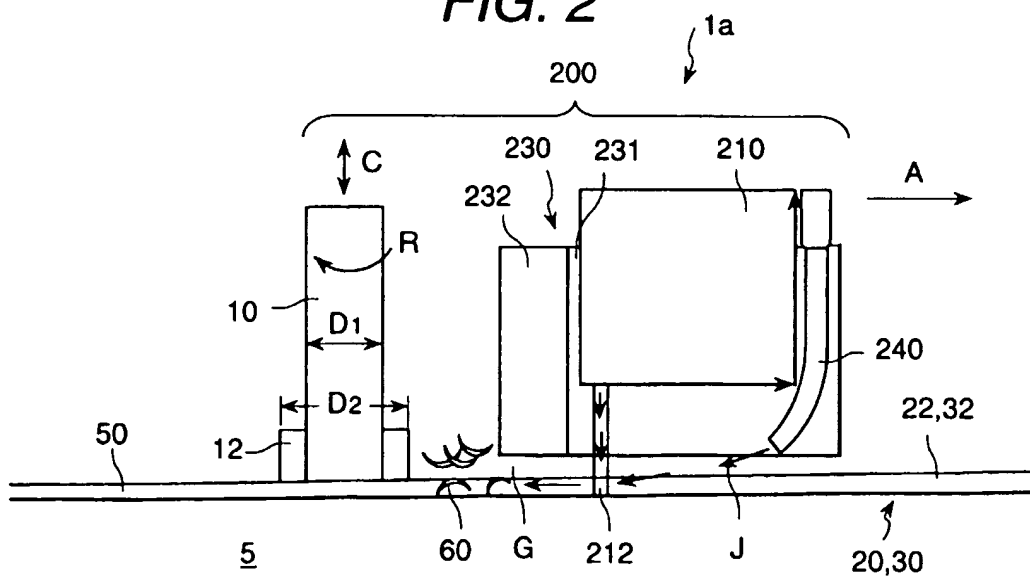


FIG. 3

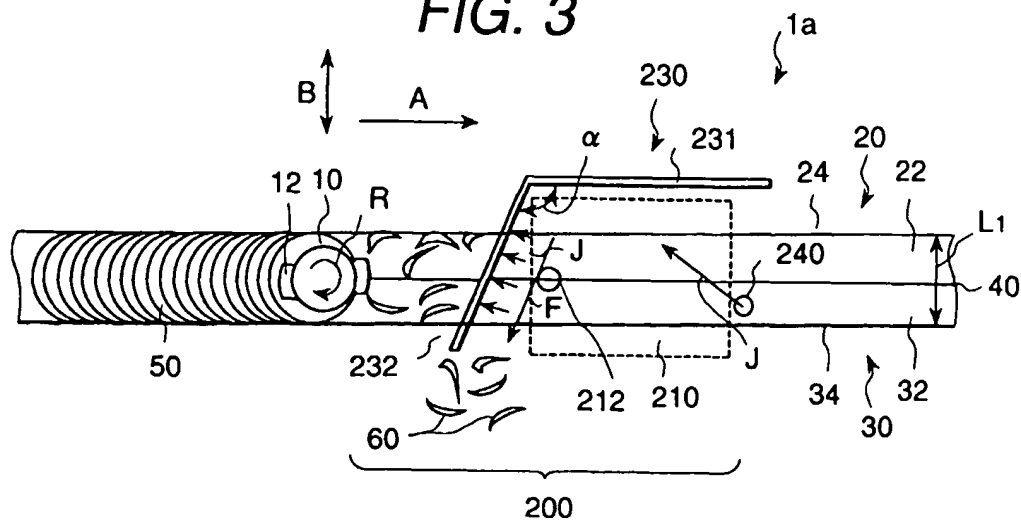


FIG. 4

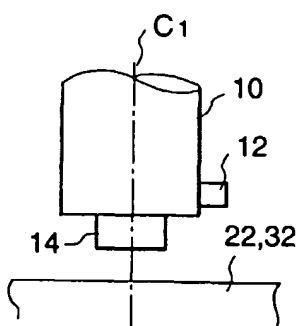


FIG. 5

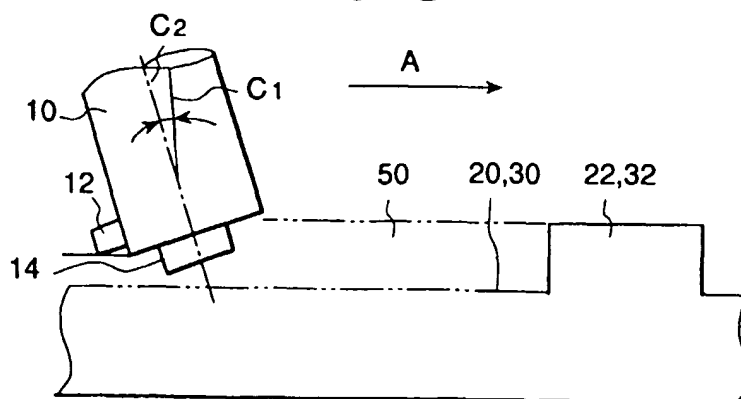


FIG. 6(A)

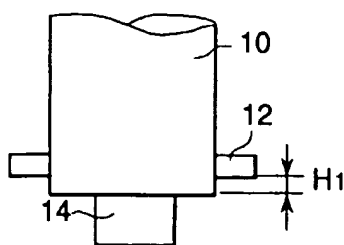


FIG. 6(B)

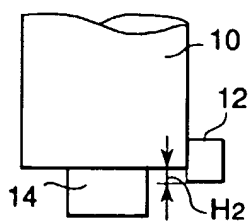


FIG. 10

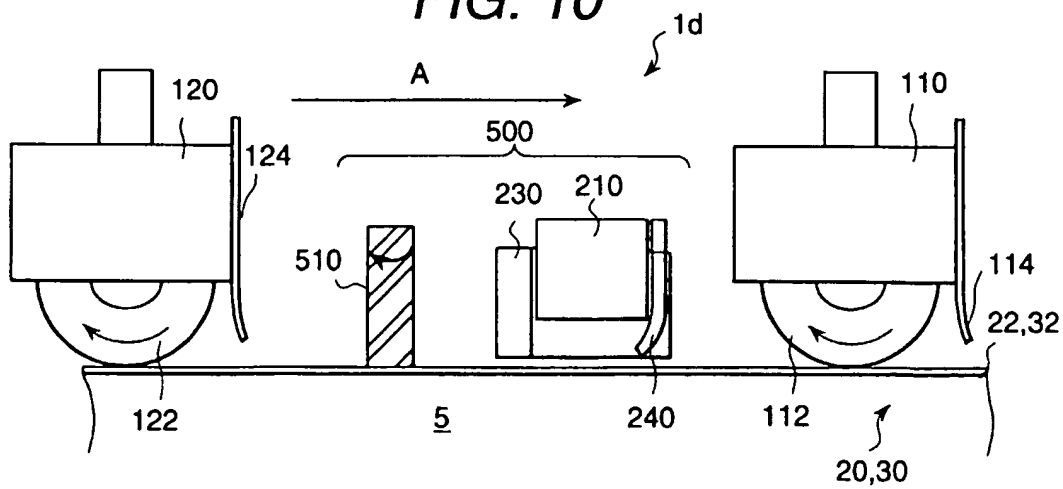


FIG. 7(A)

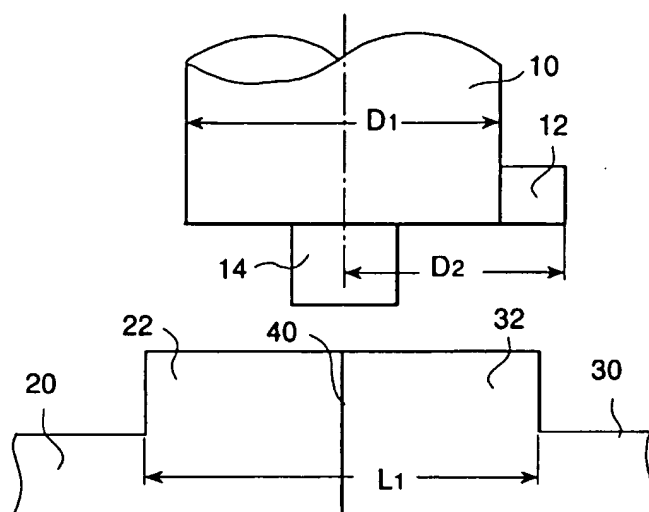


FIG. 7(B)

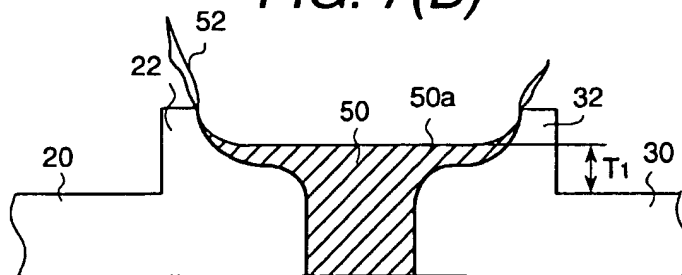


FIG. 7(C)

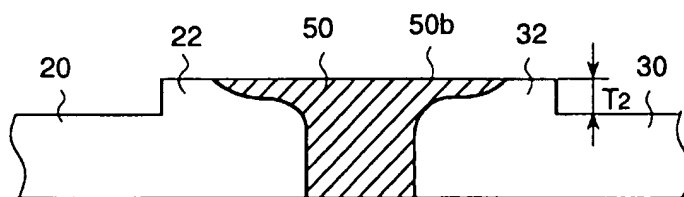


FIG. 7(D)

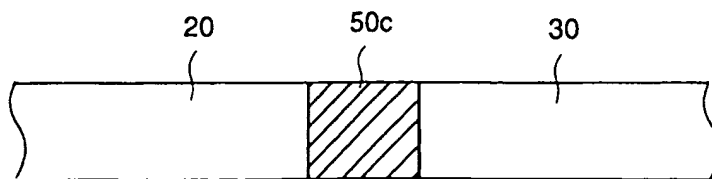


FIG. 8

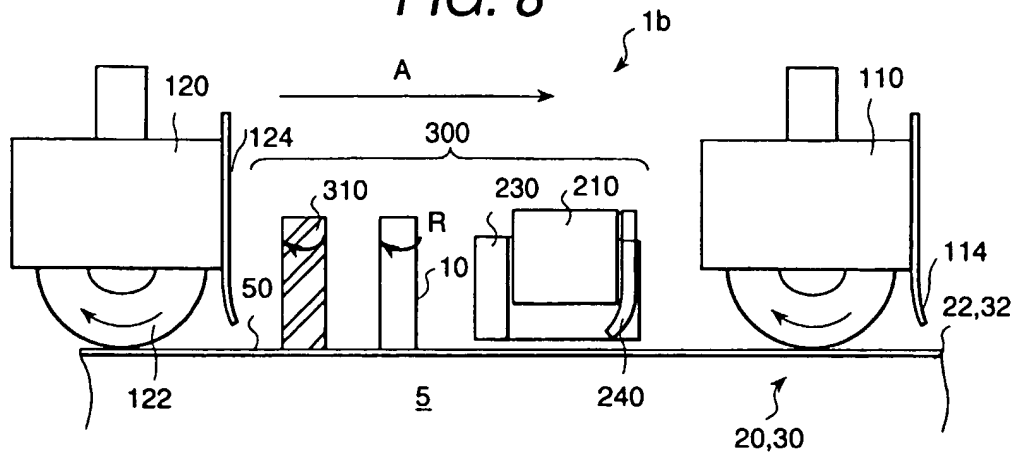


FIG. 9

